

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000925**Date Inspected:** 21-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Lefang, Sun Wei and Sha Zi			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	77, 89, 114 Meter Mock-Up & OBG		

Summary of Items Observed:

Mock-Up 77

This Quality Assurance Inspector observed ZPMC welders Xu Wei, welder identification 066253, Li Zheng Xu, welder identification 066179 and Guo Deng Yon, welder identification 037997 welding with shield metal arc welding electrode EP-E9018 H4R. Welding was being carried out on the MUA SA95 Diaphragm with welding procedure specification WPS-B-T-3312-TC-P5. Welding variables were checked and found to be 246 Amps, 24 volts, Travel Speed 139 millimeters per minute and a pre-heat of 192 degrees Celsius.

Mock-Up 89

This Quality Assurance Inspector observed tack welding of MUSB MA23, Skin Plate C weld joints. ZPMC welders were Wang Zhonghua, welder identification 053753 and Dai Lo, welder identification 048659.

Mock-Up 114

This Quality Assurance Inspector observed welding of the Skin B connection plate weld joint 2A in the flat position by ZPMC welder Jiang Zhou, welder identification 040261. Some of the essential welding variables were checked and found to be 295 amps, 32 volts, travel speed of 330 millimeters per minute and a pre-heat of 130 degrees Celsius.

OBG

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This Quality Assurance Inspector observed ZPMC welder Gung Zhi Wu, welder identification 059405 finishing the tack welding of the long and short deck plates MU3 together. There was no weld number assigned or a shop drawing available for review.



Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
